

Work Order ID 75961

November 02-11 10:41:35 AM

75961

~~U/R~~

Page 1

Item ID: D3391-025 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Aft Tube Assembly
 Start Date: 02/11/2011 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 16/11/2011 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 11/11/07 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3391	Rev H U/R/ DEO

11/11/07

100 0.00

100

Mori Seiki
 Mori Seiki CNC Lathe Large

MORI SEIKI CNC LATHE LARGE

Memo 0.00
 Turn as per Folio FA599 Rev: I & Dwg D3391 Rev: I

scribe batch # on fwd end at 90 degree

110 0.00

110

QC
 Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo 0.00

111 0.00

111

QC
 Quality Control

QC8- Inspect parts - second check

Memo 0.00

1 0
 M.L. 11/11/14
 1 0
 M.L. 11/11/14
 1 0
 11-11-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

75961

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Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run** **Start** ***NR1***
 QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** ***NR2***

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180*	Skidtubes	0.00							
Skidtubes	Memo	0.00							
Skidtubes	1-Open Aft cap pilot hole to .208" as per Dwg D3391								
	2-Drill float bag holes using DT8809 as per Dwg D3391(Holes marked "A" Only.								
	3-Drill wearplate holes as per Dwg D3391 using DT8878(Mid Tube) & DT8217 Wearplate Jig. *****Do Not Open To Finished Size*****								
	4-Drill Wearshoe holes as per DWG D3391 using DT8939 locating from 2 previously drilled aft wearplate holes.								
	5-Open wearplate holes to 0.250" and c'bore as per dwg D3391								
	6-Open up all wearshoe , wearplate to 0.297"and float bag holes to 0.328" as per Dwg D3391.								
	7-Deburr								

} DL 11/11/23

} DL 11/11/24

} ET 11-12-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Item ID: D3391-025 Accept ***N900040100*** Setup Start ***NS1***
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 Item Name: Aft Tube Assembly
 Start Date: 02/11/2011 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 16/11/2011 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC5- Inspect part completeness to step on W/O	0.00							
190									
QC	Memo	0.00							
Quality Control :									
200	Chemical Conversion Coat per QSI005 4.1	0.00							
200									
HandFinish	Memo	0.00							
Hand Finishing									
210	QC3- Inspect Part Finish	0.00							
210									
QC	Memo	0.00							
Quality Control									

6 m12/12

CF 11-12-13
SAA

1 11-12-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220		0.00							
220	Skidtubes	0.00							
Skidtubes	Memo								
Skidtubes	Instal spacers as per dwg D3391 A/R Magnabond 6398 Batch: <u>M117870</u> exp. date: <u>03/2012</u> cure time 12hrs as per QSI0015								
230		0.00							
230	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
235		0.00							
235	Pressure Wash per QSI005 4.3	0.00							
HandFinish	Memo	0.00							
Hand Finishing	AND REALODINE AS PER PAR09-043								

2 SPO 11-12-13

811216

① EF/MJ 11-12-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
240									
Powdercoat									
Powder Coating									
	Memo								
	START TIME: 10:00	0.00							
	OVEN TEMPERATURE: 320 OF								
	FINISH TIME: 10:30								
250	QC3- Inspect Part Finish	0.00							
250									
QC									
Quality Control	Memo	0.00							
260	HandFinishing	0.00							
260									
HandFinish									
Hand Finishing									
	Memo	0.00							
	1-Install inserts as per Dwg D3391								
	2-Install Aft Cap as per Dwg D3391								
	A/ R Sikaflex-241/-291 119443								
	Sikaflex expiry date: 12-1-								

Handwritten: 11/12/17

Handwritten: 1 BL 11-12-19.

Handwritten: 1 BR 11-12-19.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Required Date: 16/11/2011 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270	QC5- Inspect part completeness to step on W/O	0.00							
270									
QC	Memo	0.00							
Quality Control									
280	Identify as per dwg & Stock Location: (75908) 0412-742-043.	0.00							
280									
Packaging	Memo	0.00							
Packaging									
290	QC21- Final Inspection - Work Order Release	0.00							
290									
QC	Memo	0.00							
Quality Control									

1 BK 11-12-19,
11/12/19
mc 11-12-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

November-02-11 10:41:47 AM

Page 1

Work Order ID: 75961

75961

Parent Item: D3391-025

D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 02/11/2011

Required Date: 16/11/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev B 06-02-07 ECN773 dwg rev. D EC
 IPP Rev:C 06-03-28 Update Manuf. Instructions JLM
 IPP rev D 07.03.20 revF dwg EC
 IPP rev E 07.11.07 rev G dwg ecn 1053p EC verified by: DD
 IPP Rev:F 07-11-13 ECN 1056 DD verified by: EC
 IPP Rev:G 08-09-10 revH as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D6014-090 Manufactured No

100

Each

23.0000

1

1

D6014-090

ALUMINUM EXTRUSION

**

Location

Loc Qty

Loc Code

LG

23

66179

23

D3670-4-200

Manufactured No

230

Each

128.0000

4

4

D3670-4-200

SPACER

**

Location

Loc Qty

Loc Code

LG

36

71850

36

LG001

92

72851

92

mm. 11/11/09

SAD 11-12-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

November-02-11 10:41:47 AM

Page 2

Work Order ID: 75961

75961

Parent Item: D3391-025

D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 02/11/2011

Required Date: 16/11/2011

Start Qty: 1.00

Required Qty: 1.00

D2646

Manufactured No

270

Each

73.0000

1

1

D2646

Aft Cap

**

BR 11-12-19.

Location

Loc Qty

Loc Code

FP002

73825.

56

73294

56

FP004

5

68280

5

FP006

5

62678

5

FP-4

3

70945

1

71070

2

fp5

4

71038

4

D3537-1

Manufactured No

270

Each

108.0000

1

1

D3537-1

Wearpad

**

BR 11-12-19.

Location

Loc Qty

Loc Code

FP002

101

74436

70

74597

31

FP017

7

69817

5

70686

2

X 4095-049.

77736.

1

BR 11-13-19.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 75961

75961

Parent Item: D3391-025

D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 02/11/2011

Required Date: 16/11/2011

Start Qty: 1.00

Required Qty: 1.00

D3537-7 Manufactured No

270

Each

9.0000

1

1

D3537-7

Wearpad

*7095-047.

76537.

**

V

BR 11-12-19.

Location

Loc Qty

Loc Code

FP

4

71689

4

FP017

5

71689

5

D3553-1 Manufactured No

270

Each

37.0000

1

1

D3553-1

Gasket

**

Location

Loc Qty

Loc Code

FP013

37

56568

2

73155

35

D3553-3 Manufactured No

270

Each

22.0000

1

1

D3553-3

Gasket

**

Location

Loc Qty

Loc Code

FP

20

31631

20

FP013

2

53480

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 75961

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Parent Item: D3391-025

D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 02/11/2011

Required Date: 16/11/2011

Start Qty: 1.00

Required Qty: 1.00

D3672-1 Manufactured No

270 Each 696.0000 2 2

D3672-1

Phenolic Washer

**

BR 11-12-19.

Location

Loc Qty

Loc Code

FP-A

432

52505

0

66821

432

ST074

264

72229

264

2.

ALS4-1032-130 Purchased No

260 Each 2,279.000 14 14

AI S4-1032-130

Insert

**

BR 11-12-09

* ALS4-1032-130.

Location

Loc Qty

Loc Code

ST280

2000

119084

2000

ST281

279

117717

2

118237

12

118312

2

118386

263

14.

ALS4-1032-225 Purchased No

270 Each 2,422.000 12 12

AI S4-1032-225

Insert

**

BR 11-12-19.

Location

Loc Qty

Loc Code

ST281

2422

108696

502

110768

62

118386

858

118966

1000

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 02/11/2011

Required Date: 16/11/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C4A

Purchased

No

270

Each

2,385.000

6

6

AN3C4A

BOLT

**

BR 11-12-19.

Location

Loc Qty

Loc Code

ST350

2385

117313

2

117688

5

117872

22

118112

16

118451

2

118706

364

118838 ✓

974

119328

1000

6.

AN3C5A

Purchased

No

270

Each

1,131.000

4

4

AN3C5A

Bolt

**

BR 11-12-19.

Location

Loc Qty

Loc Code

FP-A

119749

7

115835

7

ST350

1124

116419

28

117343

17

117764

166

117872

2

118451

411

119127

500

4.

AN960C10L

*
R

NAS1149C0332 ✓

Purchased

No

270

Each

0.0000

10

10

*AN960C10I *

washer

119736.

**

10. BR 11-12-19.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DART AEROSPACE LTD		Work Order: 75961
Description: Float Skidtube (412)		Part Number: D3391-3
Inspection Dwg: D3391 Rev: H		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

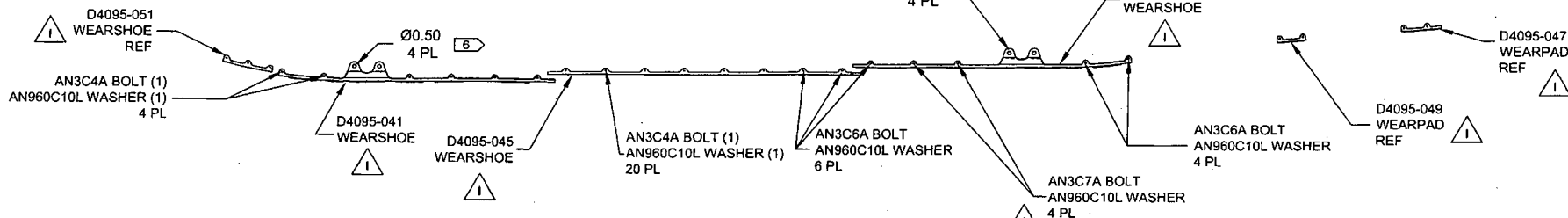
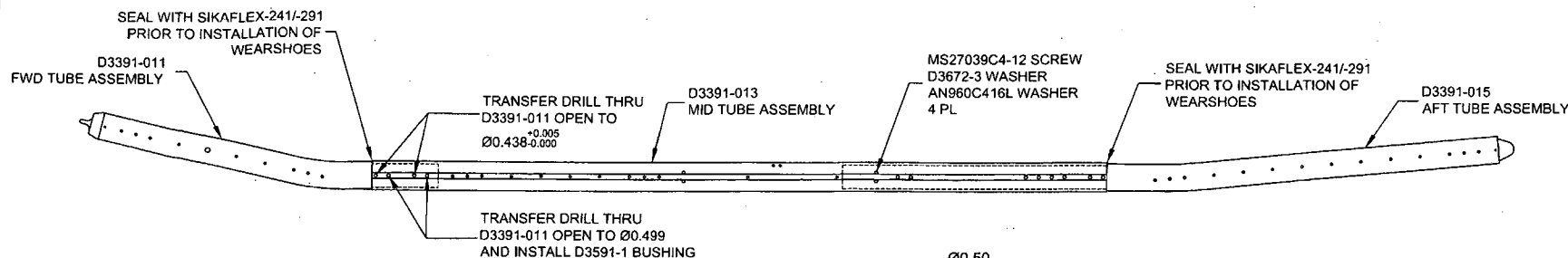
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Lathe Section						
14.000	+/-0.010	14.000	✓		tape	mm. l-02
3.500	+/-0.010	3.500	✓		vern	cwc-08
88.93	+/-0.030	88.930	✓		tape	mm. l-02
Ø3.200	+/-0.010	3.198	✓		vern	cwc-08
88.93	+/-0.030	88.930	✓		tape	mm. l-02
Ø3.750	+/-0.010	3.750	✓		vern	cwc-08
30° x 160° chamfer	+/-0.010	30° x 160	✓		ll	

Measured by: MML	Date: 11/11/10
Audited by: RQ	Date: 11.11.21

HAAS Section						
1.526	+0.000/-0.030	1.510	✓		Vern	JLM 06
7.500	+/-0.010	7.505	✓			
27.750	+/-0.010	27.750	✓			
31.750	+/-0.010	31.750	✓			
35.250	+/-0.010	35.250	✓			
3.300	+/-0.010	3.304	✓			
0.200	+/-0.010	.200	✓			
3.520	+/-0.010	3.518	✓			
0.687	+0.010/-0.000	.690	✓			
R0.062	+/-0.010	.062	✓			
Ø0.484	+0.005/-0.001	.484	✓			

Measured by: SC W	Date: 11/11/19
Audited by: RQ	Date: 11.11.21

Rev	Date	Change	Revised by	Approved
A	06.04.24	New Issue P/O D3391-015/-025	KJ/JLM	
B	06.06.19	Dwg revision update	KJ/JLM	
C	07.04.20	Ø0.208 dimension removed	KJ/JLM	
D	07.09.06	0.400 dimension removed	KJ/JLM	
E	07.11.23	Dwg Rev. updated	KJ/EC/DD	
F	09.04.27	Dimensions updated per Rev H and NCR09-028	KJ/JLM	
G	09.11.16	Dimension 0.200 removed	KJ	
H	11.06.21	Dimension 44.995 removed	KJ	



D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D3391-041	FLOAT SKIDTUBE ASSEMBLY
1	D3391-011	FWD TUBE ASSEMBLY
1	D3391-013	MID TUBE ASSEMBLY
1	D3391-015	AFT TUBE ASSEMBLY
2	D3591-1	BUSHING
4	D3672-3	WASHER
1	D4095-041	WEARSHOE
1	D4095-043	WEARSHOE
1	D4095-045	WEARSHOE
1	D4095-047	WEARPAD
1	D4095-049	WEARPAD
1	D4095-051	WEARSHOE
24	AN3C4A	BOLT
10	AN3C6A	BOLT
4	AN3C7A	BOLT
38	AN960C10L	WASHER
4	MS27039C4-12	SCREW
4	AN960C416L	WASHER

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WORK ORDER
NO. 75961 M.C.J.

GENERAL NOTES

- FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON"
AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL $\varnothing 0.297$ SIZE HOLES
FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT
WHERE INDICATED.
- FIT D4095-041 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH
APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND
TRANSFER DRILL $\varnothing 0.50$ HOLES FROM SADDLE TO D4095-041
- FIT D4095-043 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH
THE APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND
TRANSFER DRILL $\varnothing 0.50$ HOLES FROM SADDLE TO D4095-043

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2011-11-04
ECN# 11-662

I	REMOVE GASKETS AND REPLACE ALL WEARSHOES; PARTS LIST UPDATE, ZN A8-1, ZN A8-2, ZN A6-4, ZN B6-8; LPS-3 COATING REMOVED FROM NOTE 2, ZN A3-1, ZN A3-2, REMOVED INSERT AEIS-1032-130, ZN B6-4, B2-4, C7-8, C3-8; REMOVED HOLES, ZN D6-4 ZN D2-4, ZN D7-8, ZN D3-8	XDF	11.10.13
H	DRAWING UPDATED TO CURRENT STANDARDS. SHT 1 PL ADDED D3591-1 BUSHING, ZN C6 $\varnothing 0.438$ DIM WAS 4 PL. ADDED $\varnothing 0.499$ DIM AND D3591-1 BUSHING. SHT 2 PL ADDED D3591-1 BUSHING, ZN C6 $\varnothing 0.438$ DIM WAS 4 PL. ADDED $\varnothing 0.499$ DIM AND D3591-1 BUSHING. (FOR FURTHER INFO SEE DSI 9364 & NCR 08-074)	AJS	08.08.20
G	REPLACE NAS INSERTS W/ AEIS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -0111-021	PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
B	DRAWING UPDATES	PH	05.06.10
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED		DRAWING NO.	REV. I
MFG. APPR.		D3391	SHEET 1 OF 8
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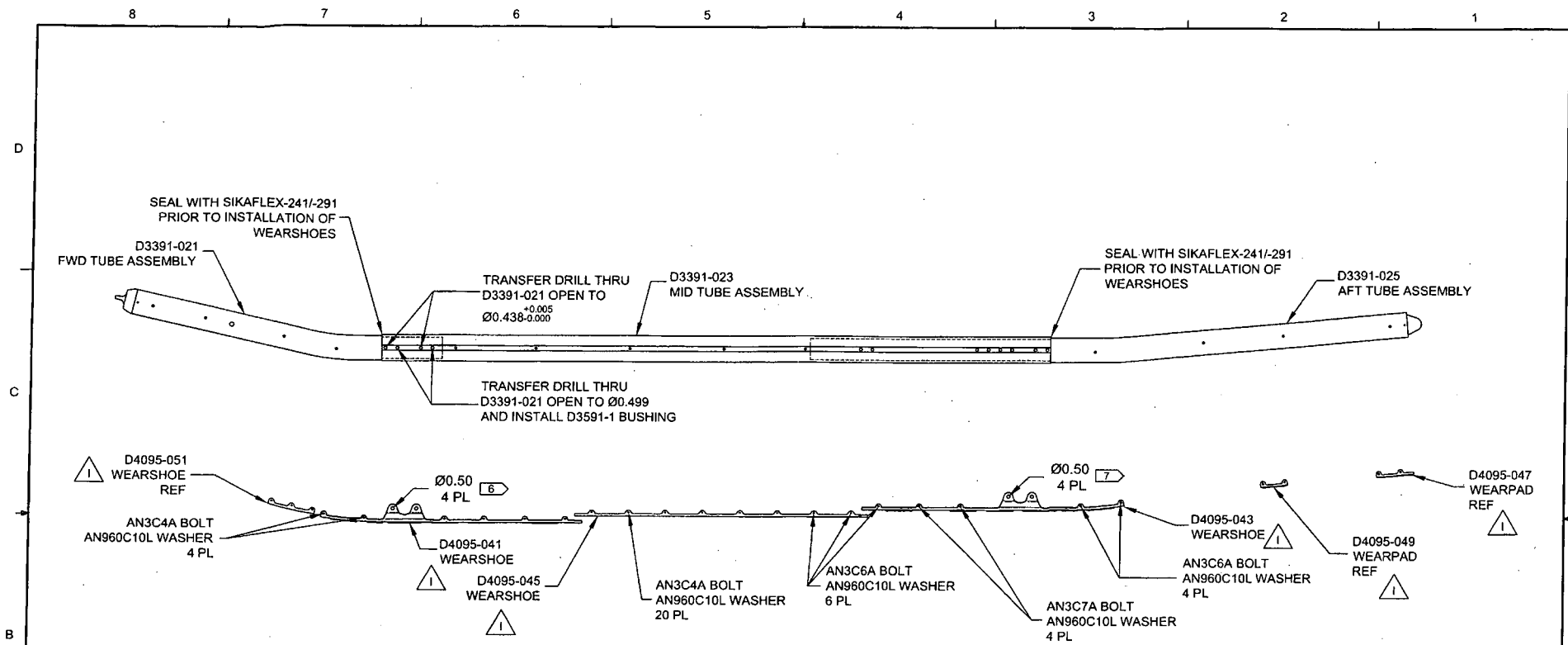
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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D3391-043 ASSEMBLY

D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
1	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
2	D3591-1	BUSHING
1	D4095-041	WEARSHOE
1	D4095-043	WEARSHOE
1	D4095-045	WEARSHOE
1	D4095-047	WEARSHOE
1	D4095-049	WEARSHOE
1	D4095-051	WEARSHOE
24	AN3C4A	BOLT
10	AN3C6A	BOLT
4	AN3C7A	BOLT
38	AN960C10L	WASHER

GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.
- 6) FIT D4095-041 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-041
- 7) FIT D4095-043 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH THE APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-043

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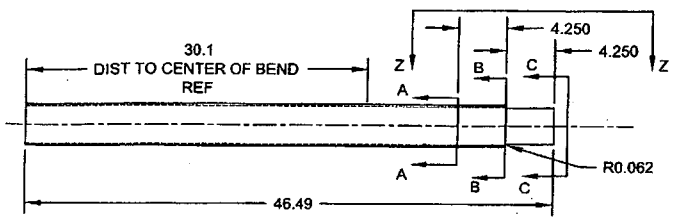
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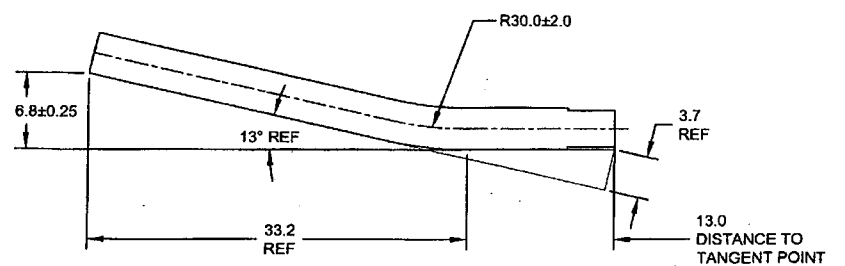
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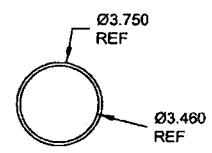
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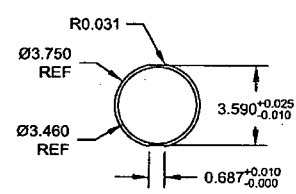
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(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



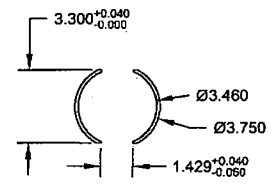
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



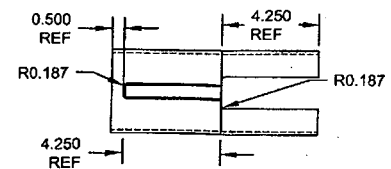
SECTION A-A
SCALE 2X



SECTION B-B
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SECTION C-C
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VIEW Z-Z
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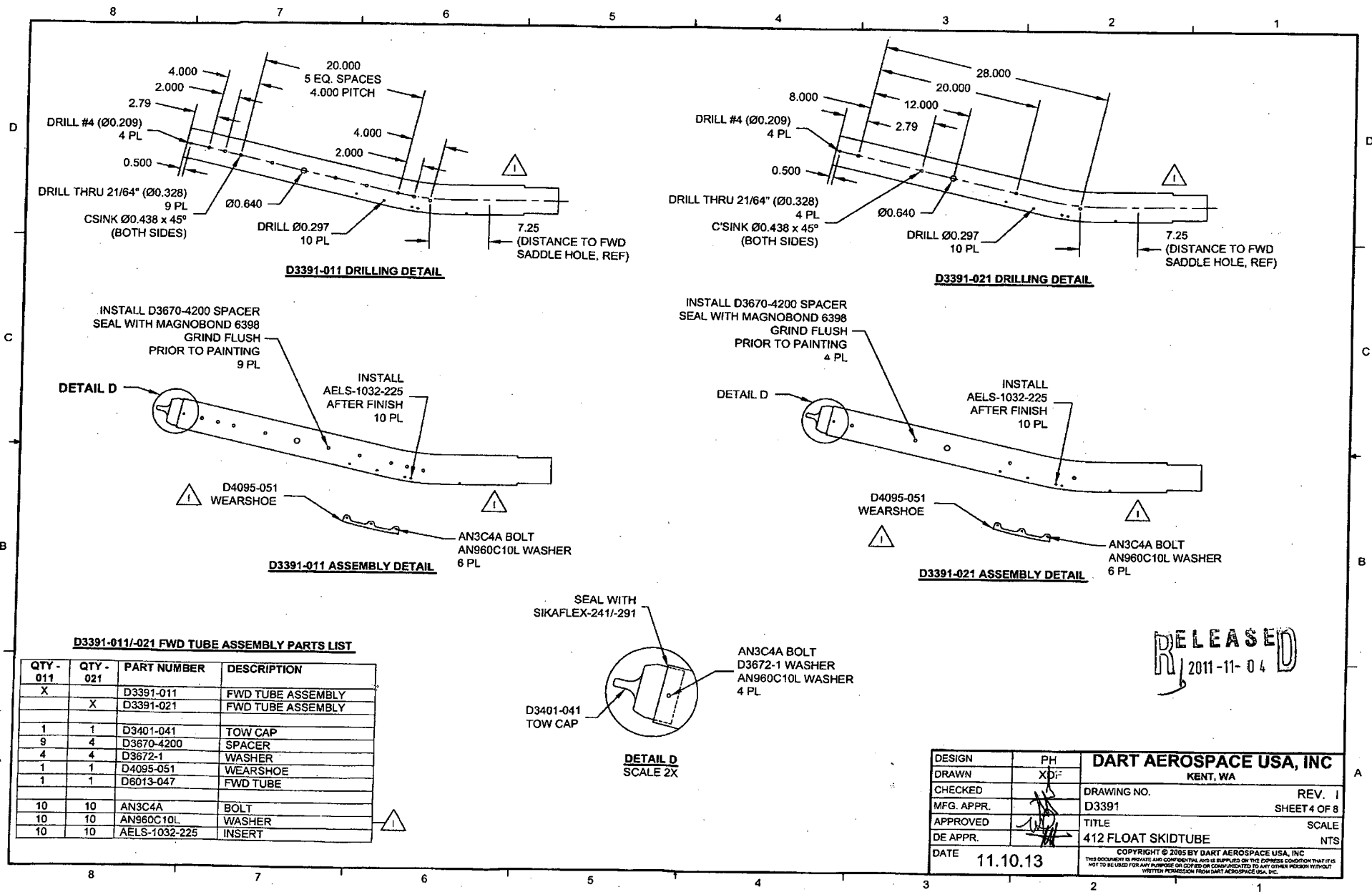
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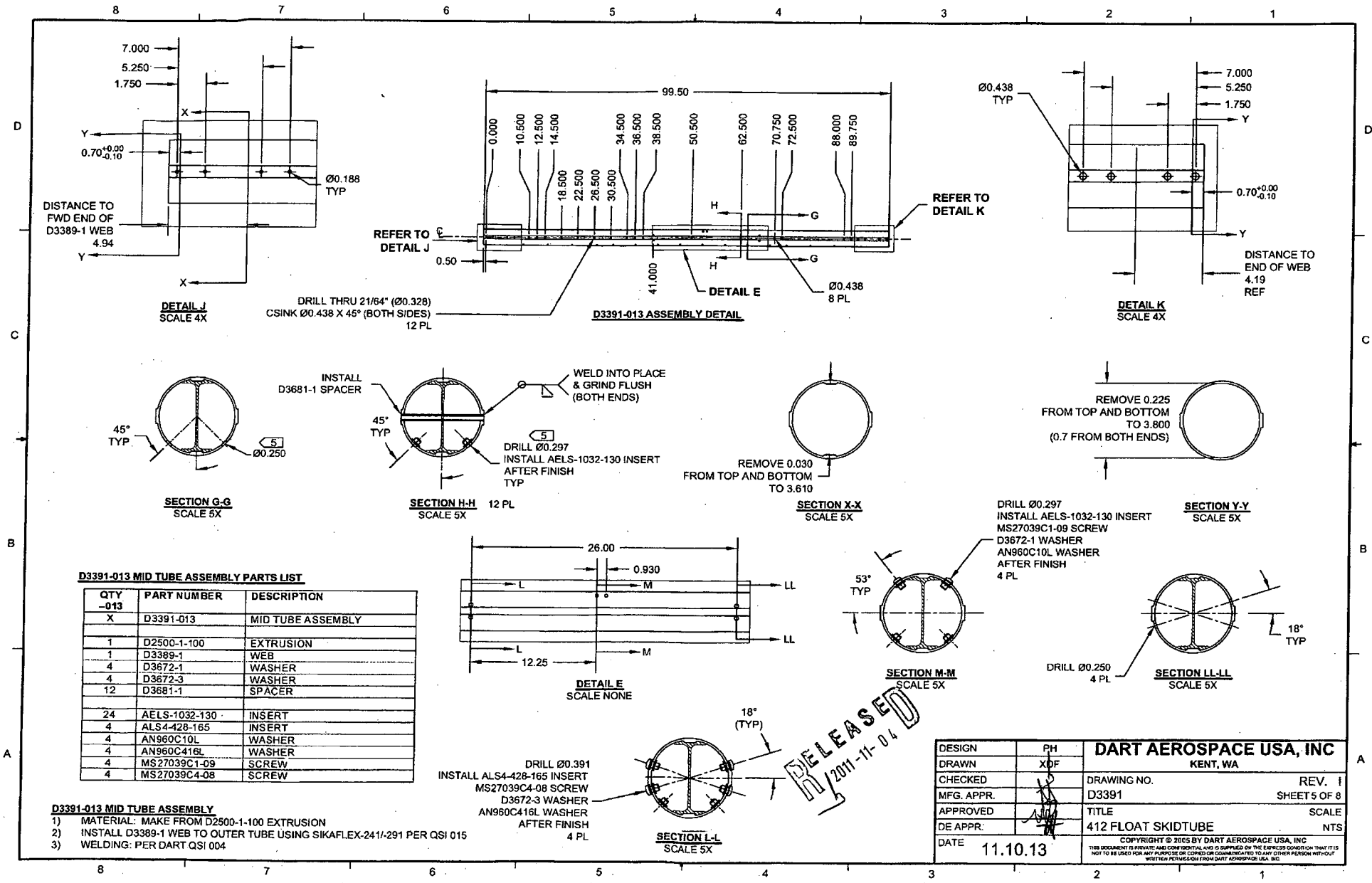
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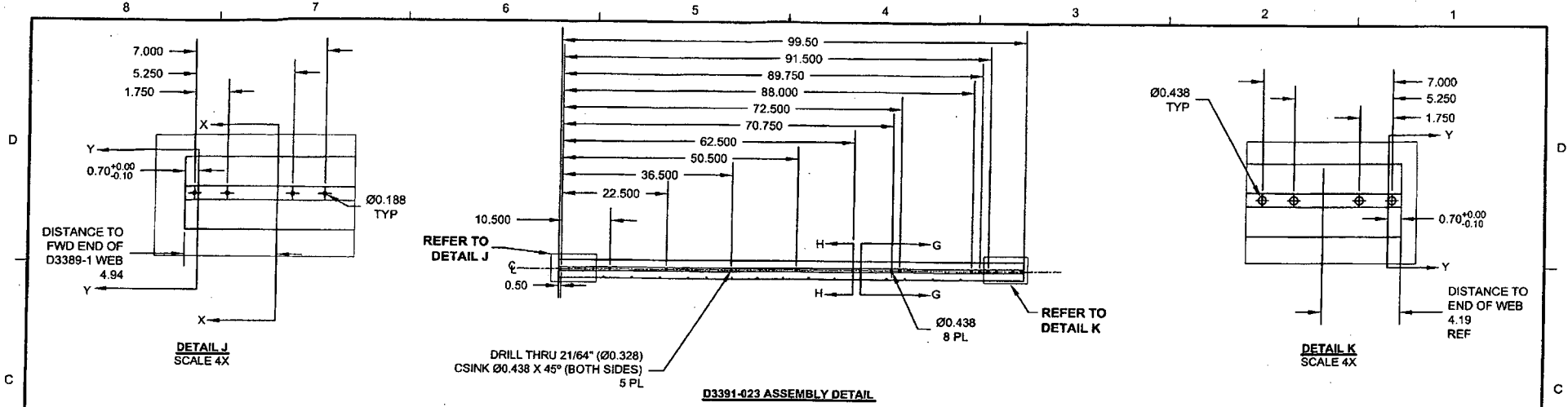
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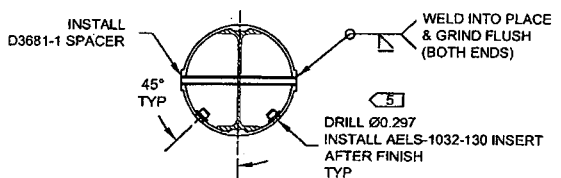
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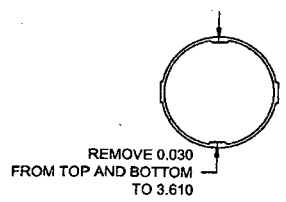
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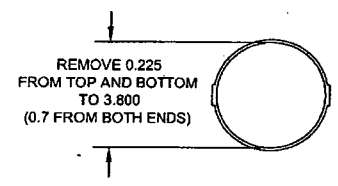
SECTION G-G
SCALE 5X



SECTION H-H
SCALE 5X



SECTION X-X
SCALE 5X



SECTION Y-Y
SCALE 5X

D3391-023 MID TUBE ASSEMBLY PARTS LIST

QTY - 023	PART NUMBER	DESCRIPTION
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT

D3391-023 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/-291 PER QSI 015
- 3) WELDING: PER DART QSI 004

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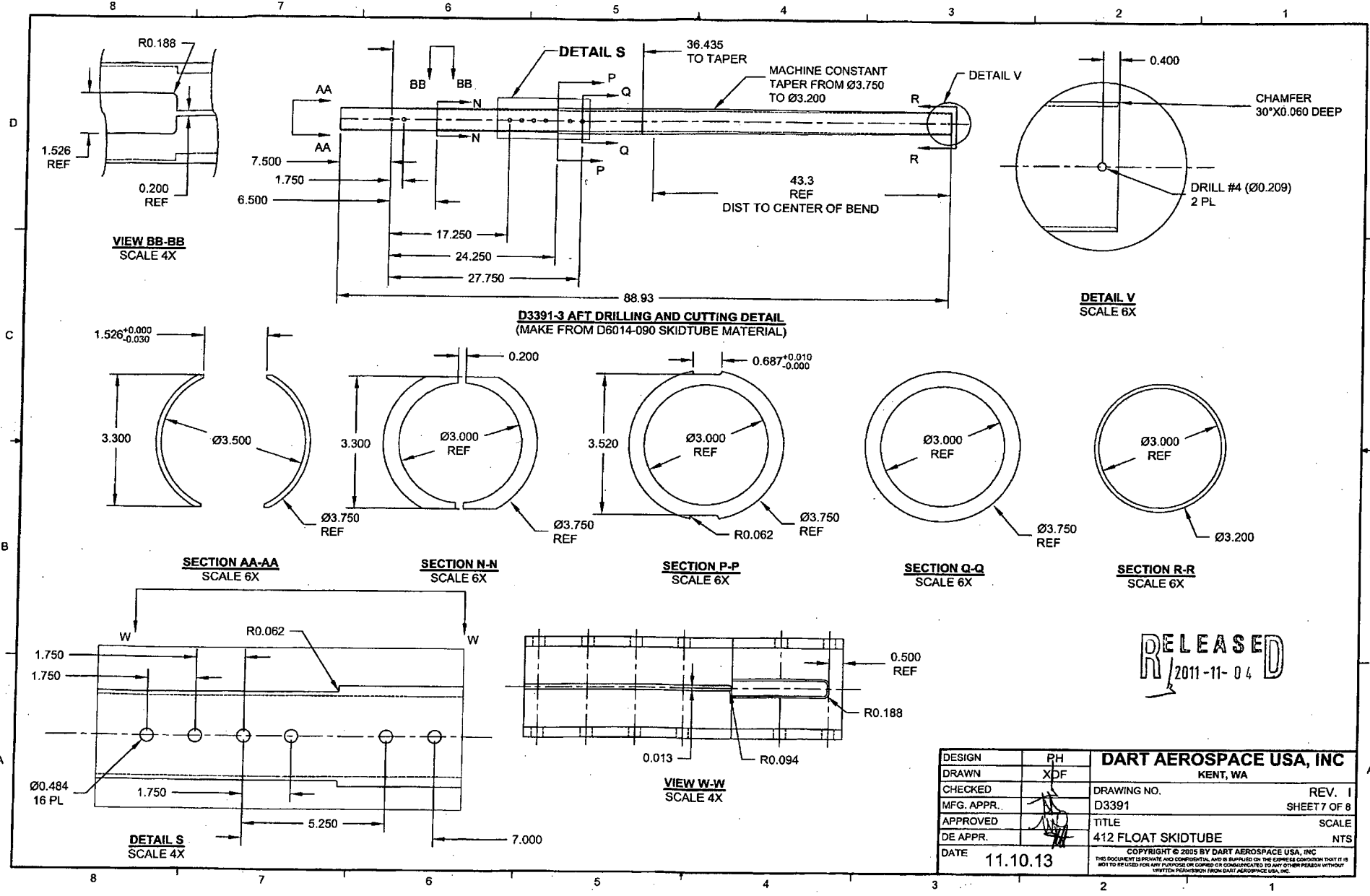
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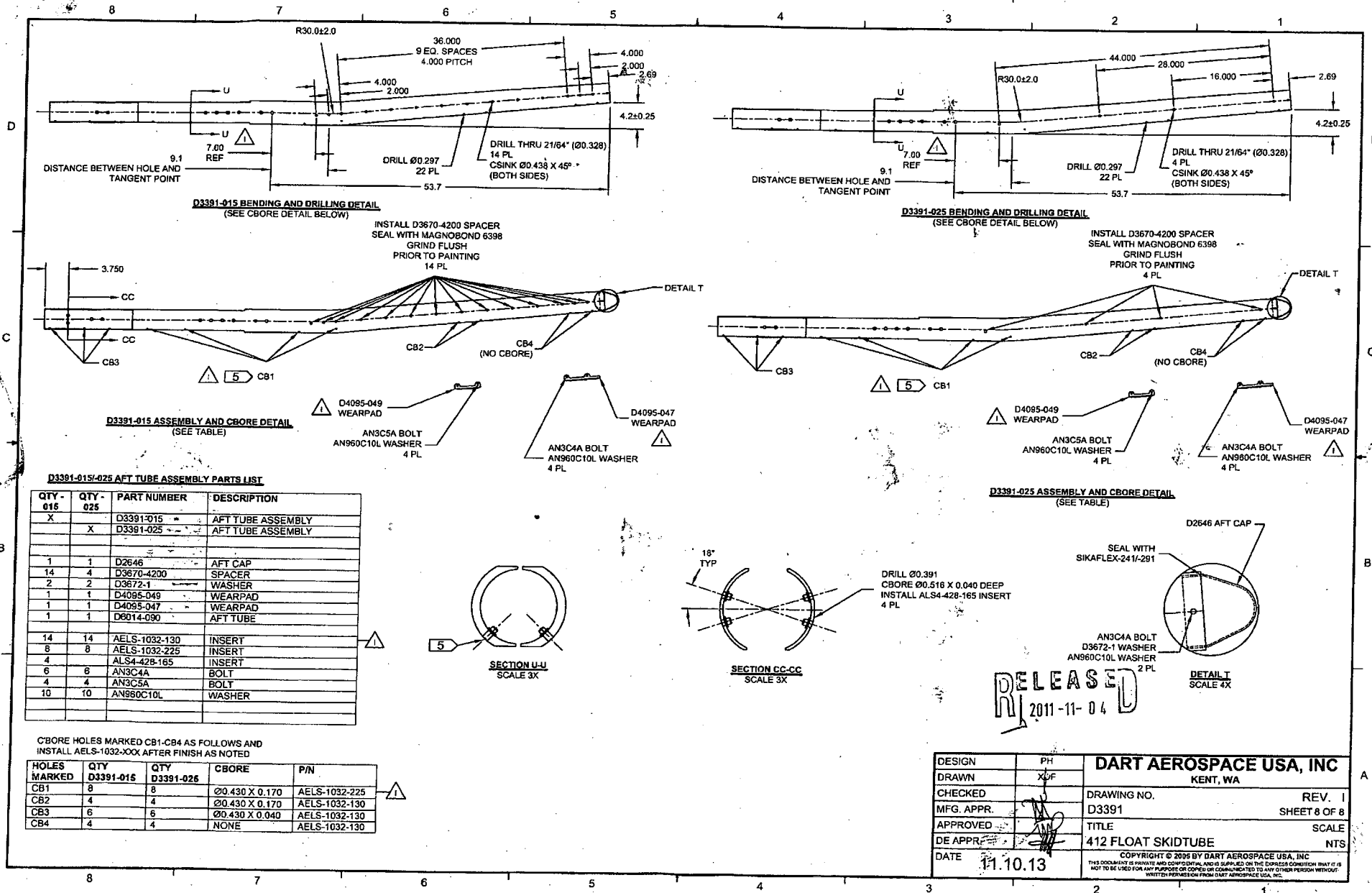
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